

Z

Work Order ID 84103

May-30-12 3:56:32 PM

\*84103\*

Page 1

Item ID: D407-667-205TRN

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Crosstube Turning Detail

Start Date: 03/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/13

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D407-667-245

Rev F

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8531 on both ends as per Folio FA248

2-Turn first side as per Folio FA248

3-Blend transition lines only, \*\*do not sand whole tube\*\*:

FOLIO REV: AA

DWG REV: 1

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

\*110\*

QC

Memo

0.00

Quality Control

1 Ø

mm. l

12/06/27

1 Ø

mm. l

12/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84103

**\*84103\***

Page 2

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Item ID: D407-667-205TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Turning Detail

Stop **\*NS2\***

Start Date: 03/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

**\*120\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA248

2-Blend transition lines only, \*\*do not sand whole tube\*\*:

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

FOLIO REV: AA

DWG REV: F

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D407-667-245

Inside of Cuff(Donot engrave on outside of tube)

1  $\phi$  KE 12-6-28

130

QC1- Inspect dimensions to dimension sheet

0.00

**\*130\***

QC

Memo

0.00

Quality Control

1  $\phi$  KE 12-6-28

W/O:		WORK ORDER CHANGES					
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Page 3

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Item ID: D407-667-205TRN

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Turning Detail

Stop

**\*NS2\***

Start Date: 03/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC8- Inspect parts - second check

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*DP*

*12-7-4*

145

0.00

**\*145\***

Crosstubes

Memo

0.00

Crosstubes

Grind off circumferential machining marks longitudinally.

*Rm*

*12-7-9*

150

Crosstubes Chemical Conversion

0.00

**\*150\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Ensure no sand is in the tube before alodine.

*u sand etch / pressure wash*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

Work Order ID 84103

\*84103\*

Page 4

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Item ID: D407-667-205TRN

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crosstube Turning Detail

Start Date: 03/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5 Inspect Chemical Conversion Coat 0.00

\*160\*

QC Memo 0.00

Quality Control

DP 12-7-13

170 Packaging 0.00

\*170\*

Packaging Memo 0.00

Packaging Identify and stock in kanban rackLocation: LG

JW 12-7-13

180 QC21- Final Inspection - Work Order Release 0.00

\*180\*

QC Memo 0.00

Quality Control

MLJ 12/07/13

MLJ 12/07/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

May-30-12 3:56:35 PM

Page 1

Work Order ID: 84103

**\*84103\***

Parent Item: D407-667-205TRN

**\*D407-667-205TRN\***

Parent Item Name: Crosstube Turning Detail

Start Date: 03/05/2012

Required Date: 17/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
 IPP Rev B 08:04.02 Removed polish EC verified by: DD  
 IPP Rev:C 08-08-19 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6011-115		Manufactured	No			120	Each	45.0000	1	1			

**\*D6011-115\***

Crosstube Material

\*\*

Location	Loc Qty	Loc Code
FG	26	
LG	19	
65180	1	
67798	18	

69802

1

man-L 12/10/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	84103
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b>	D407-667-245
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> F		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.494	/		VERN	CNC-08
	1.832	+0.005/-0.000	1.835	/			
	1.838	+0.005/-0.000	1.842	/			
	1.892	+0.005/-0.000	1.897	/			
	2.052	+0.005/-0.000	2.056	/			
	2.206	+0.005/-0.000	2.211	/			
	2.521	+0.005/-0.000	2.525	/			
	2.633	+0.005/-0.000	2.637	/			
	4.10	+/-0.030	4.10	/			
	4.978	+/-0.030	4.978	/			
	2.040	+0.000/-0.010	2.032	/			
	0.125	+/-0.010	.125	/			
	R0.063	+/-0.010	.063	/		RG	
	R0.500	+/-0.010	.500	/		RG	
SIDE B	2.490	+0.005/-0.000	2.494	/		VERN	CNC-08
	1.832	+0.005/-0.000	1.836	/			
	1.838	+0.005/-0.000	1.843	/			
	1.892	+0.005/-0.000	1.895	/			
	2.052	+0.005/-0.000	2.056	/			
	2.206	+0.005/-0.000	2.211	/			
	2.521	+0.005/-0.000	2.525	/			
	2.633	+0.005/-0.000	2.636	/			
	4.10	+/-0.030	4.10	/			
	4.978	+/-0.030	4.978	/			
	2.040	+0.000/-0.010	2.032	/			
	0.125	+/-0.010	.125	/		VERN	
	R0.063	+/-0.010	.063	/		RG	
	R0.500	+/-0.010				RG	
	112.91	+/-0.020	112.91	/		type	LG-25

Measured by: mgn-l/KC  
Date: 12/06/26

Audited by: DP  
Date: 12-7-4

Prototype Approval: N/A  
Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	
E	09.05.20	Dwg Rev updated	KJ	

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**NOTE:** Date & initial all entries

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND  
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO  
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE  
SUPPORT.  
**NOTE:** MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.  
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF  
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE  
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURNED  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITH NO MARKS  
WORK IN PROGRESS  
NO. 84103 MCT  
12/05/31

DEO ATTACHED

RELEASED

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C8-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: FAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F. REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	97	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	47	DRAWING NO.	REV. F
MFG. APPR.	47	D407-667-245	SHEET 1 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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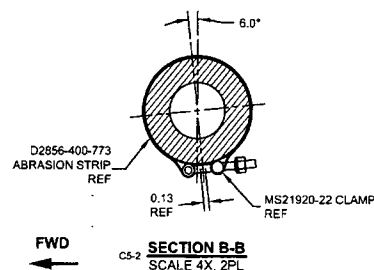
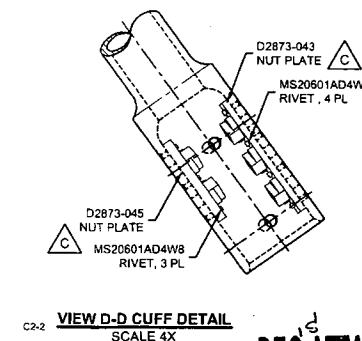
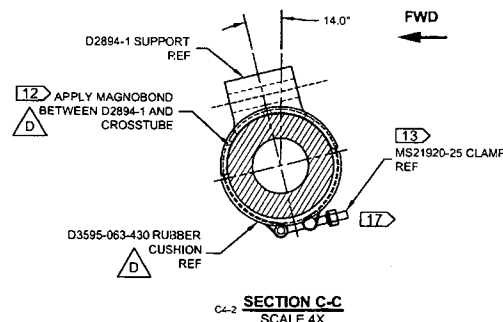
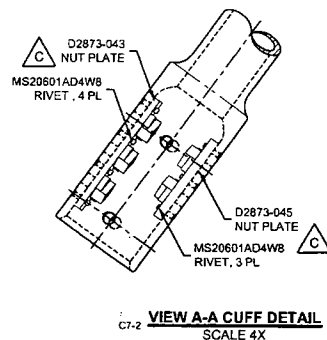
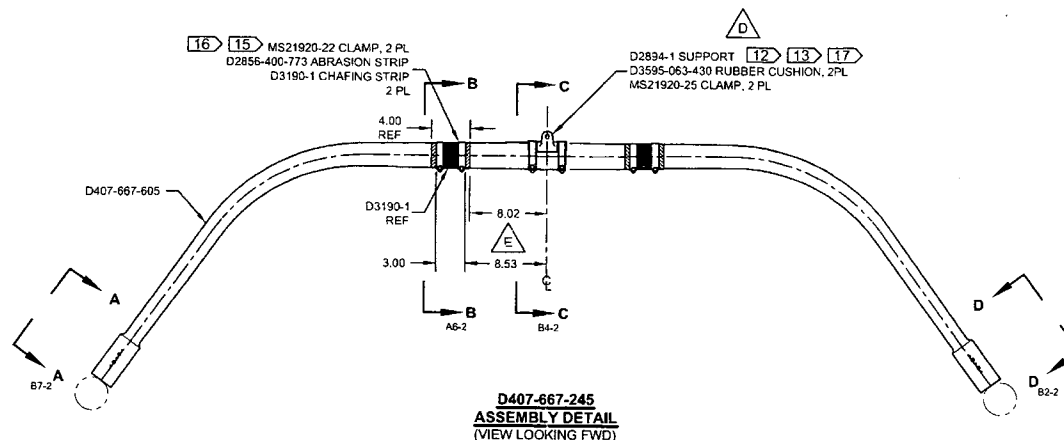
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**NOTE:** Date & initial all entries



DEO ATTACHED  
RELEASED

DESIGN	08.11.06	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. F
MFG. APPR.	4	D407-667-245	SHEET 2 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

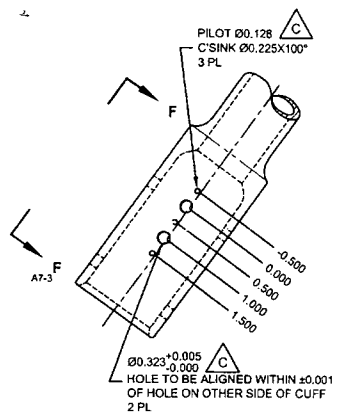
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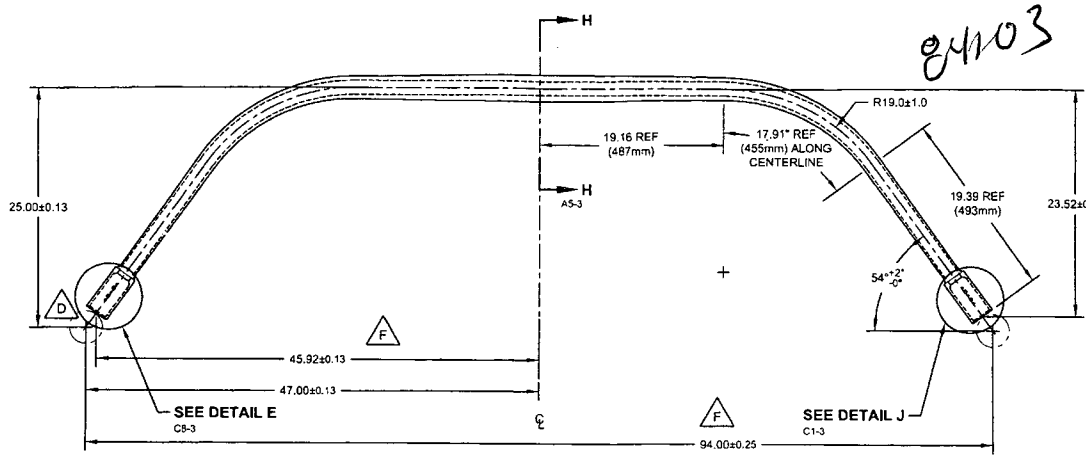


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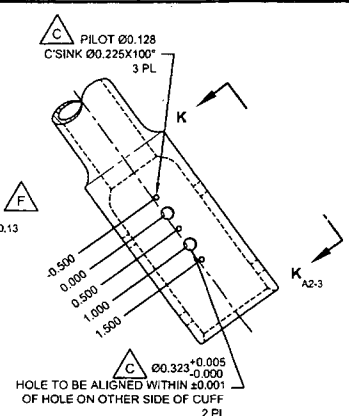
24103



**DETAIL E**  
SCALE 4X  
(VIEW LOOKING FWD)

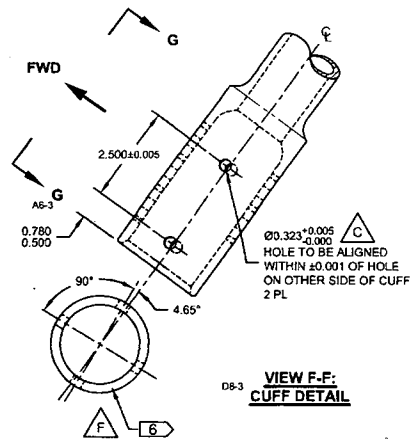


**D407-667-605**  
**BENDING AND DRILLING DETAIL**  
(VIEW LOOKING FWD)

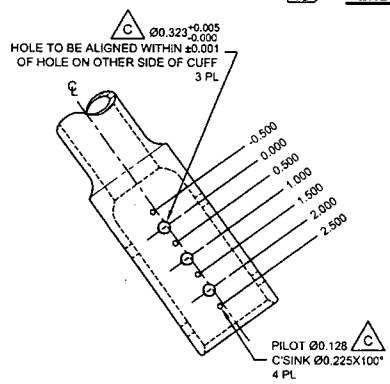


**DETAIL J**  
SCALE 4X  
(VIEW LOOKING FWD)

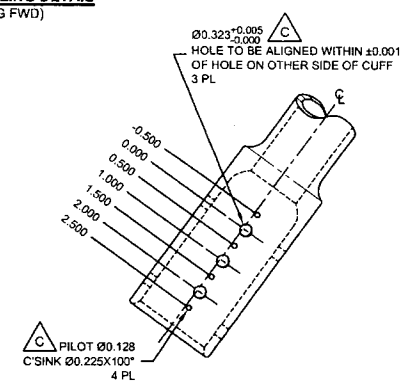
VIDEO ATTACHED  
RELEASED  
02/11/12



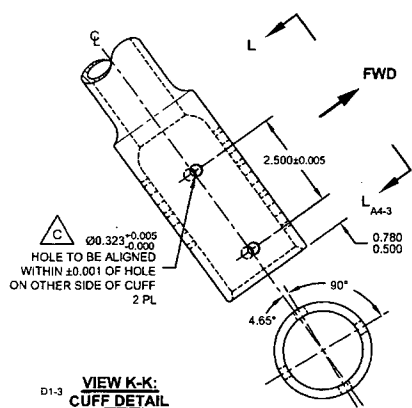
**VIEW F-F:**  
**CUFF DETAIL**



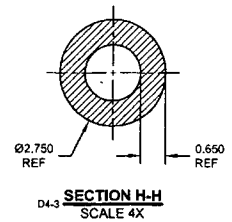
**VIEW G-G**  
(VIEW LOOKING AFT, ROTATED)



**VIEW L-L**  
(VIEW LOOKING AFT, ROTATED)



**VIEW K-K:**  
**CUFF DETAIL**



**SECTION H-H**  
SCALE 4X

DESIGN	97	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	48	DRAWING NO. D407-667-245
MFG. APPR.	48	SHEET 3 OF 4
APPROVED	48	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)
DE APPR.	48	SCALE NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD

8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

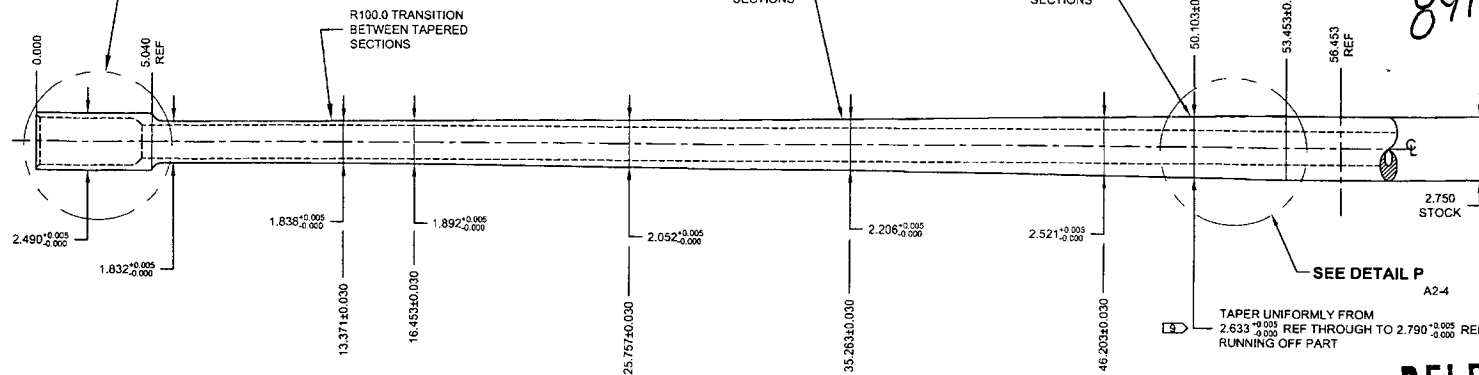
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

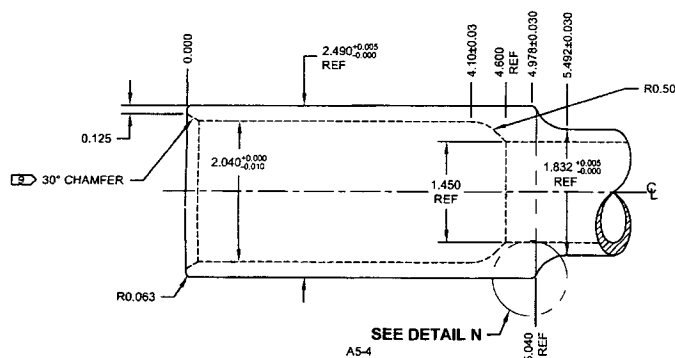
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

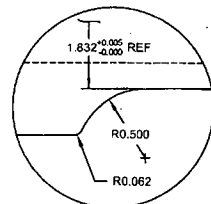
SEE DETAIL M  
A7-4



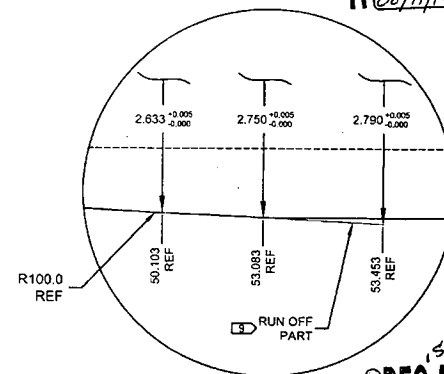
**D407-667-245 MACHINING DETAIL**



**DETAIL M: CROSSTUBE CUFF**  
SCALE 3X



**DETAIL N: CUFF TRANSITION**  
SCALE 2X



**DETAIL P: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/12

**DEO ATTACHED**

DESIGN	47	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. F
MFG. APPR.	47	D407-667-245	SHEET 4 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>40</i>	MFG. APPR. <i>E</i>	APPROVED <i>140</i>		DE APPR. <i>H</i>		
DATE 11.04.08	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12		DATE 11.04.12		

**PURPOSE:**

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

**IS:**

Item	Qty -245	Part Number	Description
3	0	D2856-400-773	ABRASION STRIP

**WAS:**

3	2	D2856-400-773	ABRASION STRIP
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NOTES 2 AND 15, SHEET 1 ARE AMENDED AS FOLLOWS:

**IS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND  
PAINT OUTSIDE PER DART QSI 005 4.2  
REMOVE MASKING AND APPLY CLEAR COAT
- 15) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1  
CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL  
PROSEALED D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT  
OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

**WAS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 REF GAP ON BOTTOM SIDE OF  
CROSSTUBE PER QSI 035.

84103  
**RELEASED**  
2011-04-18  
*MD*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

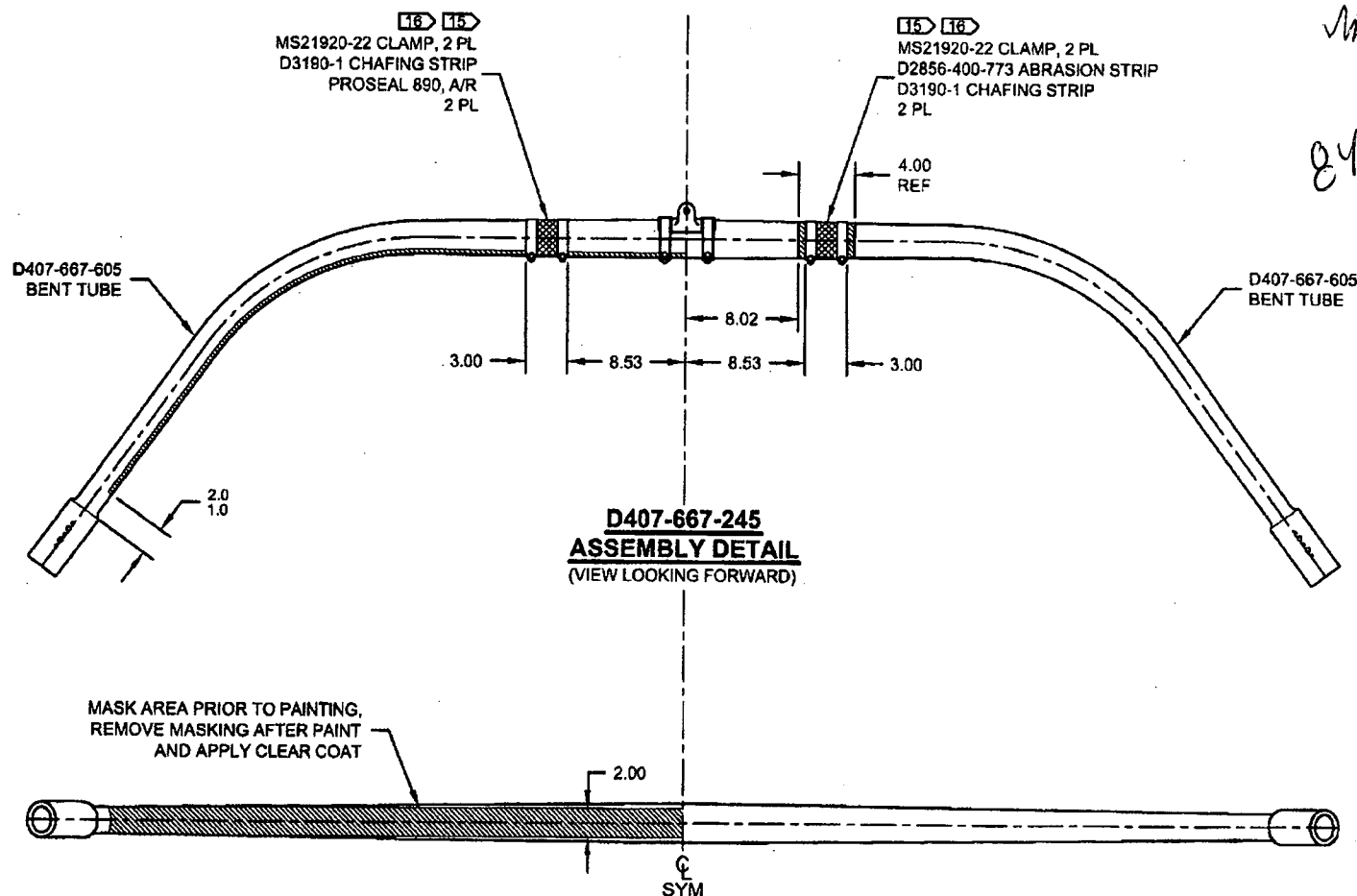
**NOTE:** Date & initial all entries

DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WJ</i>	DE APPR. <i>H</i>		
DATE 11.04.08	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

WAS:

**RELEASED**  
2011-04-18



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DRAWING NO. D407-667-245	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED AS	MFG. APPR. E	APPROVED MP		DE APPR. H		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		DATE 11.09.19		

**PURPOSE:**

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

**CHANGE:**

**IS:**

Item	Qty -245	Part Number	Description
12	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

**WAS:**

12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 17, SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

**WAS:**

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-09-29  
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

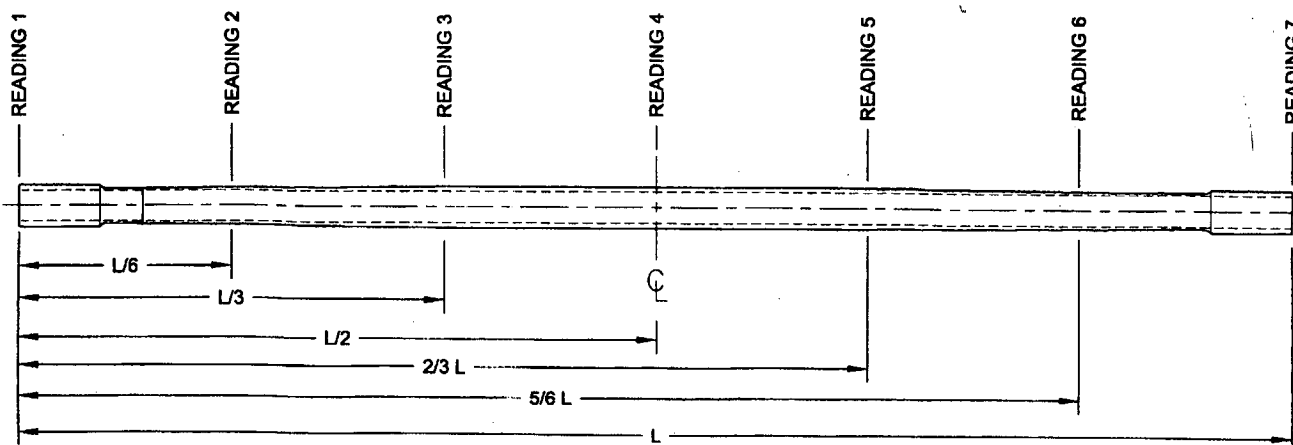
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>EV103</u>
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> <u>D407-667-245</u>
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> F		<b>Page 2 of 2</b>

### WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation $\Delta w$ (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.291	<del>.236</del> <sup>.283</sup>	.235	<del>.286</del>	.048	0.075"
READING 2 L=	.259	<del>.405</del> <sup>.236</sup>	.237	.267	.031	
READING 3 L=	.422	<del>.665</del> <sup>.405</sup>	.414	.434	.029	
READING 4 L=	.659	<del>.448</del> <sup>.665</sup>	.674	.673	.015	
READING 5 L=	.393	<del>.249</del> <sup>.440</sup>	.447	.427	.054	
READING 6 L=	.224	<del>.23</del> <sup>.249</sup>	.273	.255	.049	
READING 7 L=	.232	.231	.233	.231	.002	

#### Calibration Result

Actual Block Thickness: 100-560

Sitescan 250 Measured Thickness: 100-500

Measured by: <u>KC</u>	Audited by: <u>DP</u>	Preliminary Approval:
Date: <u>12-7-04</u>	Date: <u>12-7-4</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4" 78 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	
E	09.05.20	Dwg Rev updated	KJ	
F	12.06.04	Wall thickness form added	KJ	<u>[Signature]</u>